

Work Order ID 63302

Wednesday, October 27, 2010 10:52:18 AM



Page 1

Item ID: D212-725-1-103

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-10-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-725-1	B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

10-10-28

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>(x4)</u>			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>4</u>	<u>162</u>	<u>10-10-28.</u>	
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>4</u>	<u>0</u>		

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Page 3

Item ID: D212-725-1-103

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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 385

0.00



Packaging

Memo

0.00

Packaging

10/10/28 (7)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 (7)
10-10-28 (7)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 10:52:23 AM

Page 1

Work Order ID: 63302

Parent Item: D212-725-1-103

Parent Item Name: Doubler




Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	103.8847	0.1406	0.592			



10-10-28

Location

Loc Qty

Loc Code

MAT22

103.8847

111381

11.89

113189

0.3947

114968

91.6

114968

(4)

W/O:		WORK ORDER CHANGES					
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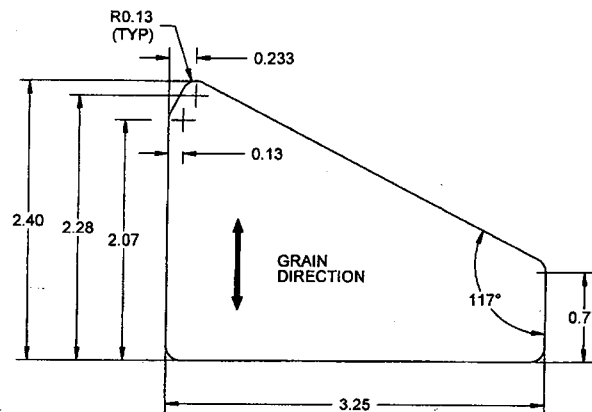
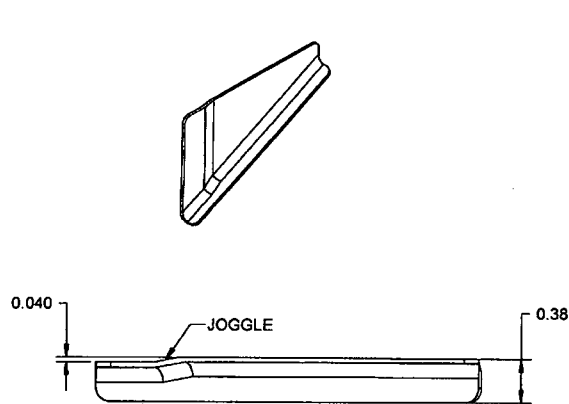
NOTE: Date & initial all entries

D212-725-1-103

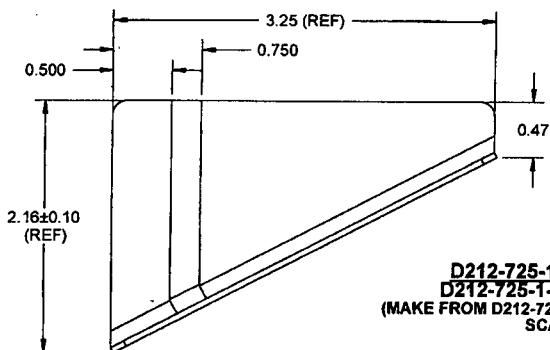
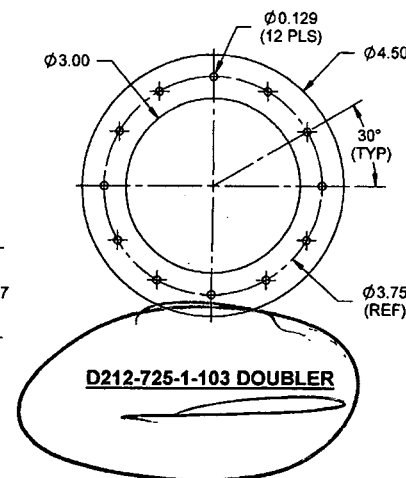
<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Measured by: IB	Audited by: S	Prototype Approval:
Date: 10-10-28	Date: 10/10/28	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revD

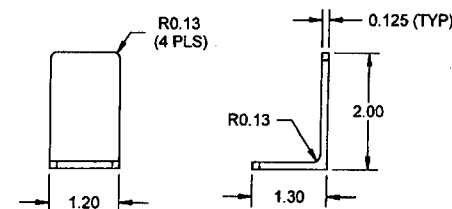


D212-725-1-113F FLAT PATTERN
SCALE 1:1



D212-725-1-113 GUSSET
D212-725-1-114 OPPOSITE
(MAKE FROM D212-725-1-113F FLAT PATTERN)
SCALE 1:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63302
2100-1027



D212-725-1-115 ANGLE

RELEASED
2009-10-20

D212-725-1-103 NOTE:

1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S0.050)

D212-725-1-113/-114 NOTE:

2) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S0.040)

D212-725-1-115 NOTE:

3) MATERIAL: 2024-T3511 (QQ-A-200/3F) ANGLE EXTRUSION (REF. DART SPEC. M2024T3-A)

GENERAL NOTES:

- 4) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 8) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN AW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. D212-725-1
DATE 07.05.11	TITLE 212S DETAIL PARTS	REV. B SHEET 36 OF 44 SCALE 1:2
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